



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4884-1

Job Sheet 180544



Part No: D4884-1

Job Qty: 6 ea

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Machining-3		
105	Doosan	6 pcs	7/20/18	7/20/18	0.00	4.51	Doosan		
110	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Machining-3		
115	CNC Vertical Machining	6 pcs	7/20/18	7/20/18	0.21	5.56	HAAS 5 Axis		
117	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Machining-3		
120	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC8 Machining-3		
130	Outsource	6 pcs	7/20/18	7/20/18	0.00	0.00	Outsource2		
140	Packaging	6 pcs	7/20/18	7/20/18	0.00	0.00	Packaging2		
150	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
160	Packaging	6 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2		
170	QC21-SA	6 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Part Op 105 - Machine blank as per Machinist's turning detail, folio+drawing D4884-1.

Descriptions: 115 - Mill as per folio FB509.

130 - ISSUE P/O :

160 - IDENTIFY AS PER QSI 044 6.1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	2.1000 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.500	2	85	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

DART AEROSPACE LTD		Work Order:	180544
Description: End Fitting, Eye		Part Number:	D4884-1
Inspection Dwg: D4884 Rev: A		Page 1 of 1	

10 Piece

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	<i>0.502</i>				
1.17	+/-0.030	<i>1.164</i>				
R0.63	+/-0.030	<i>0.625</i>				
0.500	+/-0.005	<i>0.500</i>				
0.030	+/-0.010	<i>0.025</i>				
0.017	+/-0.010	<i>0.015</i>				
Ø0.670	+0.000/-0.001	<i>0.670</i>				
30°	+/-0.5°	<i>30</i>				
Ø0.125	+0.004/-0.001	<i>0.128</i>				
30°	+/-0.5°	<i>30</i>				Test with <i>SLIO</i>
Ø0.125	+0.004/-0.001	<i>0.128</i>				
Ø1.14	+/-0.030	<i>1.140</i>				
1.132	+/-0.010	<i>1.132</i>	✓		<i>SLIO</i>	<i>Veru</i>
Ø0.750	+0.000/-0.001	<i>0.7493</i>	✓		↓	
0.66	+/-0.030	<i>0.658</i>	✓			
2.060	+/-0.005	<i>2.062</i>	✓			
R0.25	+/-0.030	<i>0.250</i>	✓		<i>Rad gauge</i>	
1.81	+/-0.030	<i>1.810</i>	✓		<i>SLIO</i>	<i>Veru</i>
3.65	+/-0.030	<i>3.653</i>	✓		↓	
0.06 x 45°	+/-0.030 x +/-0.5°	<i>0.060</i>	✓			
0.947	+/-0.010	<i>0.946</i>	✓			
0.059	+/-0.010	<i>0.062</i>	✓			
0.063	+/-0.010	<i>0.065</i>	✓			
R0.06	+/-0.030	<i>0.062</i>	✓		<i>Rad gauge</i>	
0.200	+/-0.010	<i>0.203</i>	✓		<i>SLIO</i>	<i>Veru</i>
R0.25	+/-0.030	<i>0.250</i>	✓		<i>Rad gauge</i>	
1.39	+/-0.030	<i>1.397</i>	✓		<i>SLIO</i>	<i>Veru</i>

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: <i>18/07/24</i>	Date: <i>18/08/24</i>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
Date: _____				Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Supplier ☐					
		MRB (QSI042) Approval ☐					
		Completed By ☐					
		Lead hand / Supervisor Approval Verification ☐					
		QC / QA Coordinator Approval ☐					

Environment ☐	No Re-verification ☐	Bending ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Centre Not Concentric ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Cracks ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Crimp/Kink/Ripple/Wave ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Cuffs ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Crushing ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Heat Treat ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Wave/Twist in Tube ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Marks/Chatter ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐		Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐	OTHER : _____		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S096749

Part: D4884-1

Job No: 180544

Serial No/Batch: S096749

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/28/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040840**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040840
PO Date: 8/24/18
Due Date: 8/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180541	D4881-1	Strut : Various STC's Outsource process - NDT per QSI038 4.1 ISSUE P/O C OF C IS REQUIRED	Firmed	-	8/29/18	2 pcs	0 pcs	2 pcs	\$22.25/pcs	\$44.50
Line Item Note **RUSH - need back ASAP**											
2	180544	D4884-1	End Fitting, Eye : Various STC's ISSUE P/O	Firmed	-	8/29/18	6 pcs	0 pcs	6 pcs	\$22.25/pcs	\$133.50
Line Item Note **RUSH - need back ASAP**											
Grand Total:											\$178.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/29/18 12:45 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37219	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040840
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON EIGHT PARTS AS PER PO:PO040840 ✓

Action Taken:	Date:	Initial/Stamp:																																																								
LPI AND MPI C/O IAW ASTM E-1417 REV 16 AND E-1444 REV. 16 NO CRACK FOUND MAGBENCH S/N 208123 CAL DUE: 16-OCT-2018 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165 PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142	AUG 28 2018	m DOT-APP 20 53-89																																																								
<table border="1"><thead><tr><th>Description</th><th>Location</th><th>P/N</th><th>Qty</th><th>Batch</th><th>S/N Off</th><th>S/N On</th></tr></thead><tbody><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr><tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr></tbody></table>	Description	Location	P/N	Qty	Batch	S/N Off	S/N On																																																			
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DAS
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp DOT-APP 20 53-89	Date: AUG 28 2018
Name: RAFIK MELIKJIAN		

18
18